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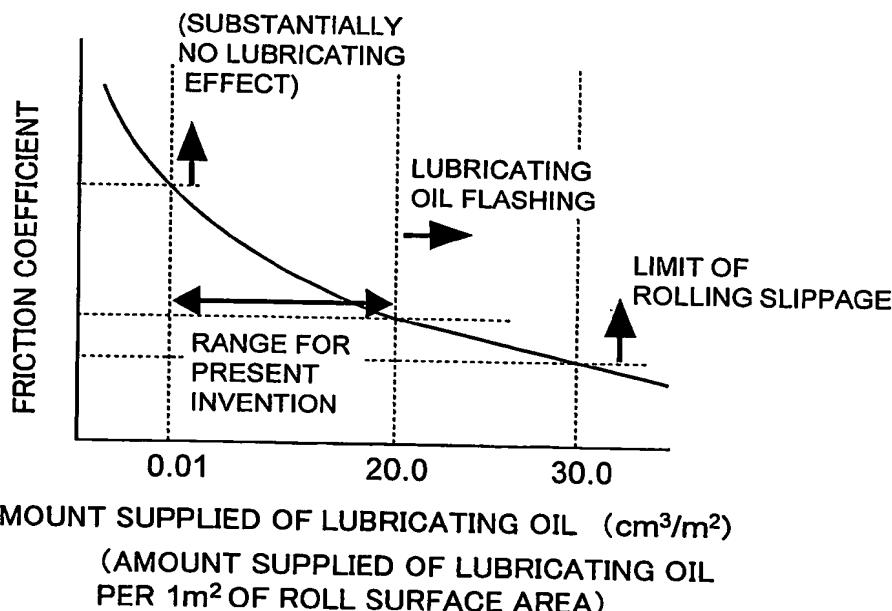
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(54) Title: LUBRICATED HOT ROLLING METHOD



AMOUNT SUPPLIED OF LUBRICATING OIL (cm³/m²)

(AMOUNT SUPPLIED OF LUBRICATING OIL
PER 1m² OF ROLL SURFACE AREA)

(57) Abstract: In a lubricated hot rolling method using a lubricating oil which contains one kind or two or more kinds among an high-basic alkaline-earth metal phenate, high-basic alkaline-earth metal carboxylate, high-basic alkaline-earth salicylate, or high-basic alkaline-earth metal sulfonate having a basicity of 40 mgKOH/g or higher, and has a viscosity at 40 C of 800 cSt or less, rolling is performed by granulating or atomizing the lubricating oil into particulates whose average size is less than 1 mm, supplying it to rolls by using a noncombustible gas whose flow rate is 2000 cm³/s or more per minute per lubricating nozzle and whose velocity is 1 m/s or more per second, and controlling the amount supplied of the lubricating oil to 0.01 cm³/m² or more and 20 cm³/m² or less per 1 m² of a surface area of the rolls.

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